Worl	der Order	II	64	178 2
Evidon	Dagamban	17	2010	7.53



Page 1

Friday, December 17, 2010 7:52:04 AM Item ID: D3414-041 Accept Setup Start Revision ID: Stop Item Name: Lug Assembly **Start Date:** 12/16/2010 **Start Qty: 10.00 Cust Item ID:** Required Date: 1/19/2011 Req'd Qty: 10.00 **Customer:** Reference: Run Start Date / Approvals: **Tooling:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID Description Qty **Run Hours** Code Qty Number Stamp **Draw Nbr Revision Nbr** D3414 Rev C 100 0.00 B 10-13-38 Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3414-1 304.100 Dwg Rev: Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00

Quality Control

QC

Memo

0.00

BG-61-01 SN

W/O:			W	ORK ORDER CHANG	GES				······································
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	egory:	NCR: Ye	es No I	DQA:	Date: _	
	Re	solution:	Dispositi	on:	QA: N/C	Closed:		Date: _	
NCR:		1	WORK ORE	DER NON-CONFORM	IANCE (N	CR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng			rification Section C	Approval Chief Eng	Approval QC Inspector

Work Order ID 64782

Friday, December 17, 2010 7:52:04 AM



Page 2

Item ID:

D3414-041

Accept



Setup Start

Stop

Stop

Reject



Pevision ID:

Item Name: Lug Assembly

Required Date: 1/19/2011

12/16/2010

Start Qty: 10.00

Req'd Qty: 10.00



Date:_____

Cust Item ID: Customer:

Tool ID

Reference:

Start Date:

Approvals:

Process Plan:

Date:_____

SPC (Y/N):

Set Up/

0.00

Run Hours

Tooling:

Date:

Tool # Plan

Code

Date:

Start Run

Reject

Qty

Number Stamp

Insp.

QC:

Sequence ID/ **Work Center ID**

120

Quality Control

Operation **Description**

QC8- Inspect parts - second check

Memo

Siloilos

Accept

Qty

130

Brake NC

Brake NC

Memo

1-Deburr

2-Form using DT8254 as per Dwg D3414

0.00

0.00

58 10/ PL/03

140

Large Fab

Memo

0.00

Large Fab

1- Weld using location Jig DT9625 as per Dwg D3414 A/R S.S. welding rod Batch: 10705

EZ 11-1-19



W/O:		to the state of th	W	ORK ORDER CHANG	ES				. 1
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	Date: _	
	Res	solution:	Dispositi	on:	_ QA: N/C C	losed:		Date: _	·
NCR:			WORK ORI	DER NON-CONFORMA	ANCE (NCI	7)			
DATE STEP		Description of NC	Description of NC Corrective Action			Verifi	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
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Work Order ID 64782

Friday, December 17, 2010 7:52:04 AM



Page 3

Item ID:

D3414-041

Accept



Setup Start

Stop



Revision ID:

Item Name: Lug Assembly

Required Date: 1/19/2011

Start Date:

12/16/2010

Start Qty: 10.00

Req'd Qty: 10.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan: _____

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Tool # Plan

Code

Run

Reject

Qty

Start

Reject

Stop

Number Stamp

Insp.

Sequence ID/ Work Center ID

150



Quality Control

Operation Description

QC9- Inspect visual per QSI004- Fusion Welds

Memo

Memo

Set Up/ **Run Hours**

0.00

Tool ID

0.00

160



Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Sulvelia

Accept

Qty

170



Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

1545 l Memo

START TIME: OVEN TEMPERATURE:

FINISH TIME:

0.00

14. BR 11-2-24

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W/O:			W	ORK ORDER CHANG	GES					÷
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Work Order ID 64782

Friday, December 17, 2010 7:52:04 AM



Page 4

Item ID:

D3414-041

Accept

Setup Start

Item Name: **Start Date:**

Revision ID:

Lug Assembly 12/16/2010

Start Qty: 10.00 Req'd Qty: 10.00

Cust Item ID: Customer:

Reference:

Required Date: 1/19/2011

Approvals:

Process Plan:

Date:

Tooling:

Start Stop

Stop

Date:___

SPC (Y/N):

Date:

Date:

Run

Reject Insp.

Work Center ID

180

Sequence ID/

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Number

Stamp

190

Identify as per dwg & Stock Location: 473

Memo

0.00

0.00

Packaging

Quality Control

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Dail Aci	ospace	Ltd								
W/O:			WC	RK ORDER CHANG	GES					-
DATE	STEP	PRO	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR	:Yes N	lo DQ	A:	Date: _	
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NCR:	,		WORK ORDI	ER NON-CONFORM	ANCE	(NCR)				
DATE		Description of NC			ction B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		on C	Chief Eng	QC Inspector
						•				
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Picklist Print

Friday, December 17, 2010 7:52:09 AM

Work Order ID: 64782

Parent Item:

D3414-041

Parent Item Name: Lug Astembly



Start Date: 12/16/2010

Required Data. 1/19/2011

Page 1

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP A□05.09.13□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA		Purchased	No			100	sf	195.3000	0.155	1.55 	22)- > {	
				Location		Loc		Loc Code			(7	
,				MAT19	112290]	195.3 6.3		1	226()	- (14)	
					112611		29		t,	()39(U	_	_	
					113062		128		_		_		
•					113077		32		_	****	_		
D3414-3	111 11 100 1	Manufactured	No			140	Each	14.0000	1	10			
 										EL_	11-1	1-19	
				Location		Loc	Oty	Loc Code					
				ST			14				_		
					62978		14			/4	_		

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		WO	RK ORDER CHANG	ES				į
STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Res	olution:	Disposition	:	_ QA: N/C Cld	sed:		Date:	····
		WORK ORDE	R NON-CONFORMA	NCE (NCR)			
STED	Description of NC				Verific	ation	Approval	Approval
SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	n C	Chief Eng	QC Inspector
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		:PAR #: Resolution: Description of NC	STEP PROCEDURE CHAN PAR #: Fault Category Resolution: Disposition WORK ORDE STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORMA STEP Description of NC Section A Section A Section Description	PAR #: Fault Category: NCR: Yes for the second section of NC Section A Section B Sign &	STEP PROCEDURE CHANGE By Date :PAR #:Fault Category:NCR: Yes No DQA Resolution:Disposition:QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty :PAR #:Fault Category:NCR: Yes No DQA: Resolution:Disposition:QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr :PAR #:Fault Category:NCR: Yes No DQA:Date: Resolution:Disposition:QA: N/C Closed:Date: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC

DART AEROSPACE LTD	Work Order:	64782
Description: Lug Bracket	Part Number:	D3414-1
Inspection Dwg: D3414 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
Dimension		Dimension			<u> </u>	
Ø0.313	+0.006/-0.001	.314	प		V 1307	
1.19	+/-0.030	1.184	de		ν	
1.00	+/-0.030	1.610	¥		V	
3.38	+/-0.030	3,374	¥		V	
5.350	+/-0.010	5.349	X 9		V	
6.23	+/-0.030	७.२२८	d		V	
2.500	+/-0.010	2.499	a		V	
0.37	+/-0.030	364	Я		V	
0.100	+/-0.010	,100	Y		V	
		ı			,	
					·	
	•					

Measured by:	B	Audited by: S	Prototype Approval:	N/A
Date:	10-13-38	Date: 11 01/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.02.28	New Issue P/O D3414-041	KJ/DD	
В	09.05.27	Dimensions updated per Dwg Rev B	KJ 10	
С	09.10.16	Dwg Rev updated to Rev C	KJ X	N

	•				X				
W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	Re	esolution:	Disposition	:	_ QA: N/C	Closed: _	· · · · ·	Date: _	
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ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	х	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG

D3414-041 LUG ASSEMBLY

1) MATERIAL: N/A

D

1) MAIERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: 0.52 lbs

SHOD REPERMI ENGINEE COL

UNCONTROLLABATE

SUBJECT TO AND CONTROL

WITHOUT NOTICE

WORK ORIGER NO. 64282 P/10-12-17

BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3) CP 09.06.17 DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO 'B' SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198), FLAT SPOTS REMOVED FROM -1 (PART NOW 'TL' SHAPED) FOR EASE OF MANUFACTURE. BY 3 ADDED TO LERANCE TO 3.230 DIM. C.2-3 1.72 DIM WAS 1.20. AJS 08.09.23 NEW ISSUE A CP 05.03.16 REV. DESCRIPTION BY DATE

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. C D3414 MFG. APPR. SHEET 1 OF 3 APPROVED TITLE SCALE DE APPR. LUG ASSEMBLY NTS COPYRIGHT © 2005 BY DART AEROSPACE LTD DATE

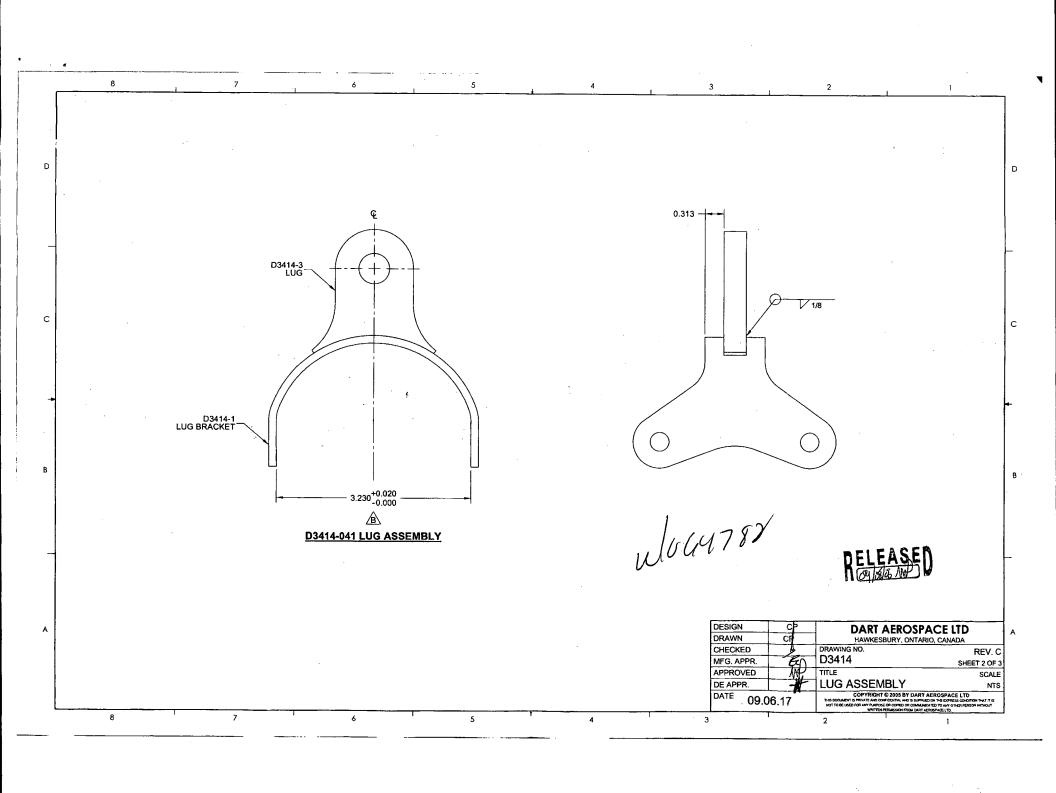
09.06.17

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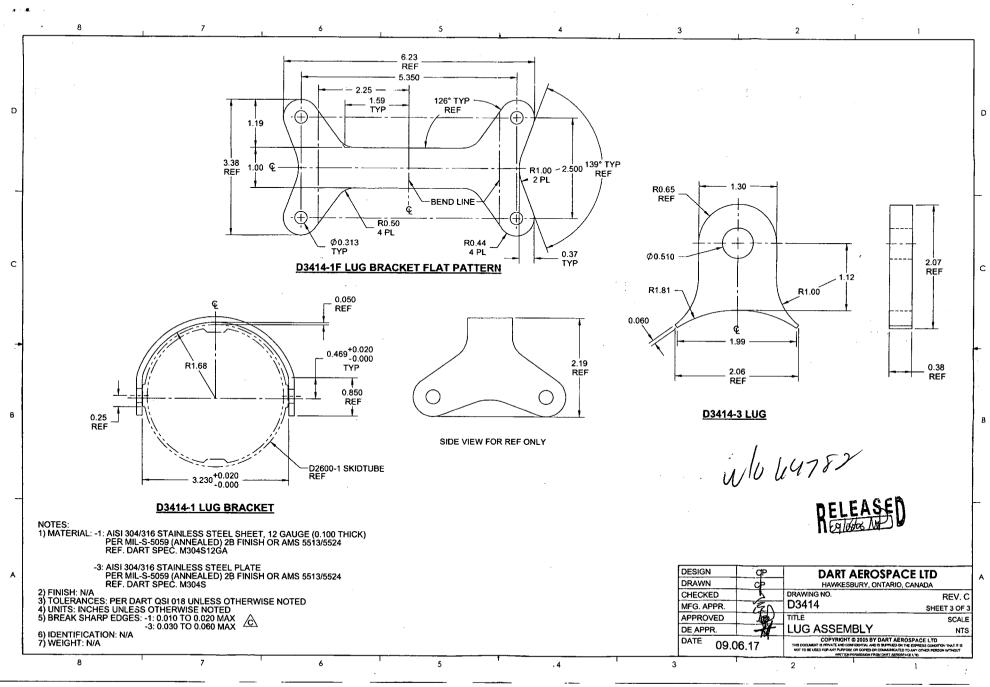
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W/O:			W	ORK ORDER CHANC	SES				1
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:PAR #: Resolution:		Fault Category: NC			s No DQ	A:	: Date:		
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			WORK ORDER NON-CONFORM						
DATE	STEP	Description of NC Section A	Corrective Action S		ction B Sign		cation tion C	Approval Chief Eng	Approval QC Inspector
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W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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	Res	solution:	Disposition	QA: N/C Closed:			Date:			
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DATE	STEP	Description of NC	Corrective Action Section				cation	Approval	Approval	
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Part No:F			Fault Category: N							
	R	esolution:	_ Disposit	ion: Q	A: N/C C	osed:	<u></u>	Date: _		
NCR:		W	ORK OR	DER NON-CONFORMANC	E (NCF	₹)				
DATE STEP		Description of NC Section A	Initial	Corrective Action Section B Action Description	Sign & Section				Approval QC Inspector	
			Chief Eng	Chief Eng	Date					
					,					